

Work Order ID 85912

85912

Page 1

June-18-12 2:30:35 PM

Item ID: D3546-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Clip

Stop ***NS2***

Start Date: 18/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Stop Friday

Approvals: Process Plan: MLJ

Date: 12/06/18 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3546

Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3546

Dwg Rev: A

Prog Rev: 15

2-Deburr if necessary

304, 050

10 0 Jm 12-6-19

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

10 0 Jm 12-6-19

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

S. L. 6/12/20

(40)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Page 2

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Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 18/06/2012 **Start Qty:** 10.00

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Customer:

Required Date: 02/07/2012 **Req'd Qty:** 10.00

10

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------------|---------------|------------------|----------------|
|---------------|---------------|------------------|----------------|

0.00

130

NC BRAKE

0.00

Brake NC

Memo

Brake NC

Form as per Dwg D3546

140

QC5- Inspect part completeness to step on W/O

0.00

140

Memo

0.00

QC

Quality Control

150

Identify as per dwg & Stock Location: 241

0.00

150

Memo

0.00

Packaging

Packaging

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

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Page 3

June-18-12 2:30:35 PM

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N900040100

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Stop ***NS2***

Item Name: Clip

Start Date: 18/06/2012 Start Qty: 10.00

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Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 10.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

MLJ 12/06/22

MLJ 12/06/22

| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

June-18-12 2:30:38 PM

Page 1

Work Order ID: 85912

85912

Parent Item: D3546-1

D3546-1

Parent Item Name: Clip

Start Date: 18/06/2012

Required Date: 02/07/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 06-09-27 JLM
remove finish DD 10.03.29 verified by:EC

IPP Rev:B

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304S18GA

Purchased

No

100

sf

163.3649

0.04

0.421053

M304S18GA

304/316 .050 Sheet

**

Jun 12-6-19

Location

Loc Qty

Loc Code

MAT020

163.364947

120604

8.66421

121626

70.2

121660

84.500737

~~19188~~

121626

~~19188~~

Dart Aerospace Ltd

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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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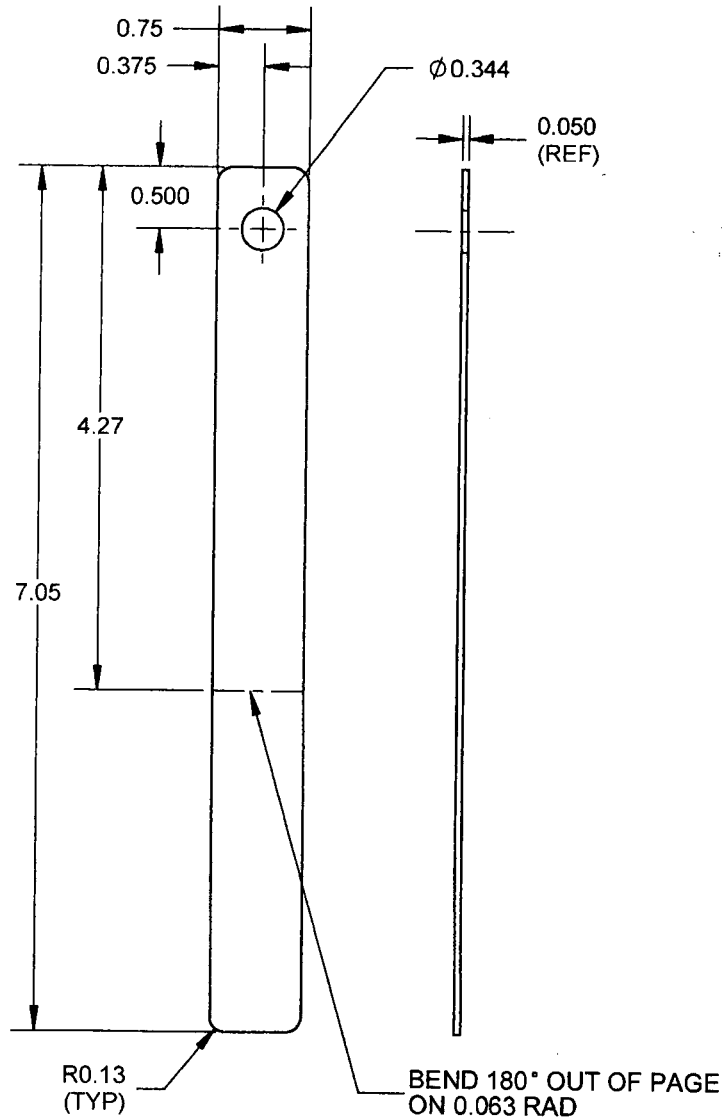
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

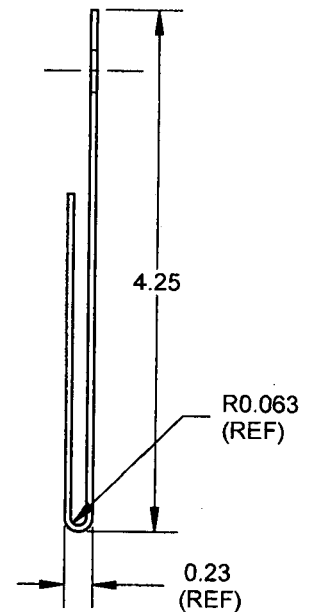
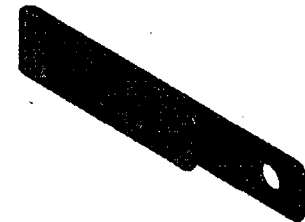
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NOTE: Date & initial all entries

| DESIGN <i>LE</i> | DRAWN BY <i>LE</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
|-------------------------|--------------------------------|--|------------------------|
| CHECKED <i>qp</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3546 | REV. A SHEET 1 OF 1 |
| DATE 06.09.15 | TITLE CLIP | | SCALE 1:1 |
| REV | DATE | DESCRIPTION | |
| A | 06.09.15 | NEW ISSUE | |



D3546-1F FLAT PATTERN



D3546-1 CLIP

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL 0.050 THICK (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85912 MLC
12/06/18

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